must ship/be assembled - Nov 18

126378

| | | Accept | *N9000401 00* | Setup | Start | *NS1* |

Item ID: D3537-9

Revision ID:

Item Name: Wearpad   Stop   *NS2*

Start Date: 11/06/14   Start Qty: 20.00   *20*   Cust Item ID:

Required Date: 11/13/14   Req'd Qty: 20.00   *20*   Customer:

Reference:

Run   Start   *NR1*

Approvals: Process Plan: _____   Date:_____   Tooling: _____   Date:_____

Stop   *NR2*

QC: _____   Date:_____   SPC (Y/N): _____   Date:_____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3537	**Revision Nbr** D								
110 *110* Waterjet FLOW CNC Waterjet	FLOW WATER JET	0.00							
	Memo 1-Cut D3537-1 as per Dwg D3537	0.00				⟨20⟩	____	DC IY/11/06	
	Dwg Rev: _D_								
	Prog Rev: _D_								
	2-Deburr if necessary								
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB	0.00							
	Memo	0.00				⟨20⟩	___	R/DC IY/11/06	

/

126378

Item ID:	D3537-9		Accept	***N9000401n0***	Setup	Start	***NS1***
Revision ID:						Stop	***NS2***
Item Name:	Wearpad						
Start Date:	11/06/14	Start Qty: 20.00	***20***	Cust Item ID:			
Required Date: 11/13/14		Req'd Qty: 20.00	***20***	Customer:			
Reference:							

Approvals: Process Plan: _____ Date: _____   Tooling: _____ Date: _____ | Run | Start | ***NR1*** |

QC: _____ Date: _____   SPC (Y/N): _____ Date: _____ | | Stop | ***NR2*** |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 ***130*** QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(20)	___	___	DAS 38 NOV 0 7 2014
140 ***140*** Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.00 0.00		DAS 30 9-89		20	___	___	14/11/07
150 ***150*** QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(20)	___	___	DAS 38 9-89 NOV 0 7 2014

Item ID:	D3537-9		Accept	*N9000401OO*	Setup	Start	*NS1*
Revision ID:						Stop	*NS2*
Item Name:	Wearpad						

Start Date:	11/06/14	Start Qty: 20.00	*20*		Cust Item ID:		
Required Date:	11/13/14	Req'd Qty: 20.00	*20*		Customer:		
Reference:							

| Approvals: | Process Plan: _____ | Date: _____ | Tooling: _____ | Date: _____ | Run | Start | *NR1* |
| | QC: _____ | Date: _____ | SPC (Y/N): _____ | Date: _____ | | Stop | *NR2* |

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Large Fab Large Fab	Weld per dwg A/R Hardcoat S.S. Batch:_____ Large Fab Memo A/R 2059B Hardcoat BATCH: M130 MS	0.00 0.00				20			14-11-10 MSC
170 *170* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				20	14-11-11		DAS 50 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(20)			DAS 38 9-89

NOV 1 1 2014

Work Order ID   126378   *126378*

November-06-14 6:59:04 AM

| Item ID: | D3537-9 | Accept | *N9000040100* | Setup | Start | *NS1* |

Item ID: D3537-9

Accept   *N9000040100*   Setup   Start   *NS1*

Revision ID: Stop   *NS2*

Item Name: Wearpad

Start Date: 11/06/14   Start Qty: 20.00   *20*   Cust Item ID:

Required Date: 11/13/14   Req'd Qty: 20.00   *20*   Customer:

Reference:

Approvals: Process Plan: _____   Date:_____   Tooling: _____   Date:_____   Run   Start   *NR1*

QC: _____   Date:_____   SPC (Y/N): _____   Date: _____   Stop   *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* HandFinish Hand Finishing		0.00				20			DAS 41 9-89 14-11-15
	Memo APPLY TEXTURED COATING ON CONCAVE SURFACE AS PER DWG AND QSI BATCH: 130617	0.00							
200 *200* QC Quality Control	QC3- Inspect Part Finish	0.00				(20)			DAS 38 9-89 NOV 17 2014
	Memo	0.00							
210 *210* Packaging Packaging	Identify as per dwg & Stock Location: FP-001	0.00				X20			
	Memo	0.00							

Item ID:	D3537-9	
Revision ID:		
Item Name:	Wearpad	

Accept ***N9000401OO*** Setup Start ***NS1***

Stop ***NS2***

Start Date:	11/06/14	**Start Qty:** 20.00	***20***	**Cust Item ID:**
Required Date:	11/13/14	**Req'd Qty:** 20.00	***20***	**Customer:**
Reference:				

Run Start ***NR1***

Stop ***NR2***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 ***220*** QC Quality Control	QC21- Final Inspection - Work Order Release	0.00						14/11/17	
	Memo	0.00							

Work Order ID: 126378

126378

Parent Item: D3537-9

D3537-9

Parent Item Name: Wearpad

Start Date: 11/06/14 **Required Date:** 11/13/14

Start Qty: 20.00 **Required Qty:** 20.00

Comments: IPP REV:A 14.11.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	473.5356		3			
M304S16GA									**			Dec 14/11/06	
304/316 Sheet .063													

Location	Loc Qty	Loc Code	
MAT020	360.1356		
M127821	71.317		
M129449	192.8186	3.3888	
M130745	96		
TPI	113.4		
M129545	113.4		
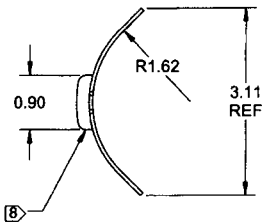
D3537-1 WEARPAD
(MAKE FROM D3537-1F)
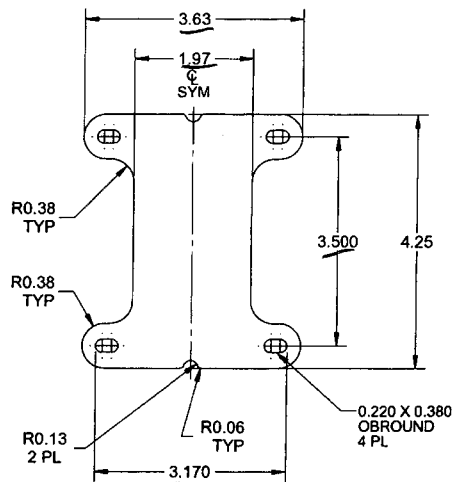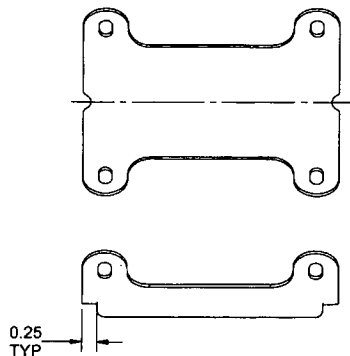
R1.62
0.90
3.11 REF
8
0.25 TYP

D3537-1F FLAT PATTERN

3.63
1.97
SYM
R0.38 TYP
R0.38 TYP
3.500
4.25
R0.13 2 PL
R0.06 TYP
0.220 X 0.380 OBROUND 4 PL
3.170
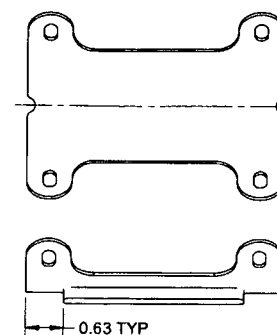
NOTES:
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-1" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.42 lbs
8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
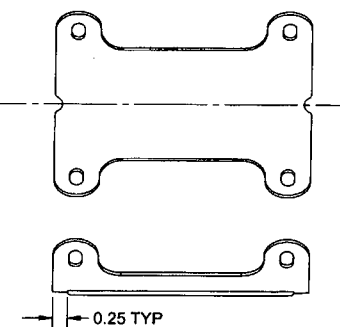9) WELDING: PER QSI 004
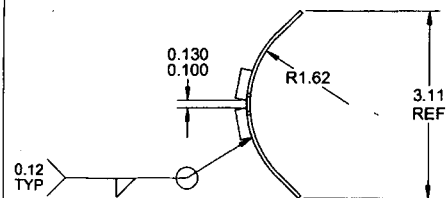
D3537-5 WEARPAD
(MAKE FROM D3537-1F)

0.130
0.100
R1.62
3.11 REF
0.12 TYP
0.63 TYP

NOTES:
1-5) AS PER D3537-1
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-5" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.42 lbs
8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
9) WELDING: PER QSI 004
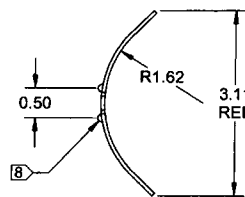
D3537-9 WEARPAD
(MAKE FROM D3537-1F)

R1.62
0.50
3.11 REF
8
0.25 TYP

NOTES:
1-5) AS PER D3537-1
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-9" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.19 lbs
8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
9) WELDING: PER QSI 004
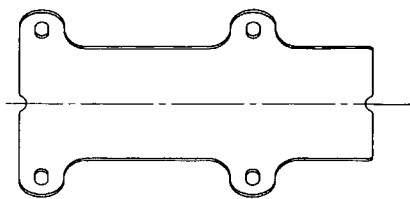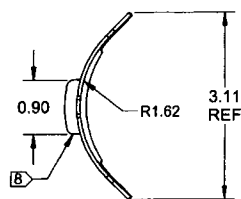10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2014-11-05

REV.	DESCRIPTION	BY	DATE
D	RE-FORMAT DRAWING, ADD -9/-11 WEARPADS	DB	14.10.16
C	WIDEN TAB TO 0.380, WELD PATTERN	CB	07.04.13
B	ADD AMS 5513 AND AMS 5524	CB	07.03.20
A	NEW ISSUE	CB	06.11.06

DESIGN	CB	**DART AEROSPACE USA, INC.**	
DRAWN	DB	KENT, WA	
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 1 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	14.10.16		

APPROVED

D3537-3 WEARPAD
(MAKE FROM D3537-3F)

0.90
R1.62
3.11 REF
8
1.22 FLAT
0.25 TYP
0.10 JOG
15°

D3537-3F FLAT PATTERN

5.86
3.500
R0.06 TYP
R0.13 2 PL
3.63
3.170
℄ SYM
1.97
0.220 X 0.380 OBROUND 4 PL
R0.38 TYP
R0.38 TYP

NOTES:
1) MATERIAL: AISI 304/316 SS SHEET ANNEALED, 16 GAUGE (0.063) PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240 PER DART SPEC M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-3" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.50 lbs
8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
9) WELDING: PER QSI 004
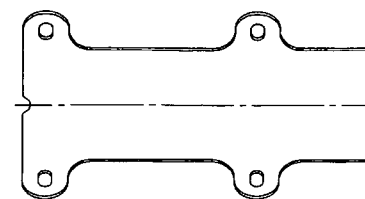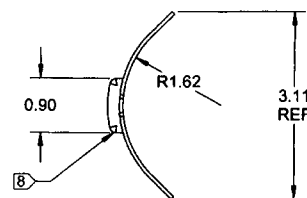
D3537-7 WEARPAD
(MAKE FROM D3537-3F)

0.90
R1.62
3.11 REF
8
0.25 TYP
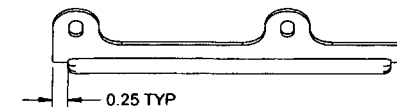
NOTES:
1-5) AS PER D3537-3
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-7" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.50 lbs
8) APPLY 2 LAYERS OF 2059B HARDCOAT WELD TO WITHIN 0.25 OF WEARPAD ENDS, 0.19 TO 0.25 THICK
9) WELDING: PER QSI 004
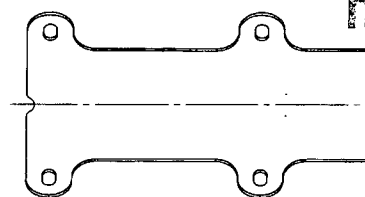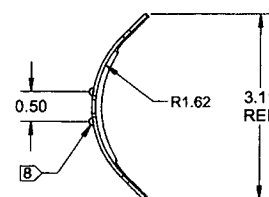
D3537-11 WEARPAD
(MAKE FROM D3537-3F)

0.50
R1.62
3.11 REF
8
1.22 FLAT
0.25 TYP
15°
0.10 JOG
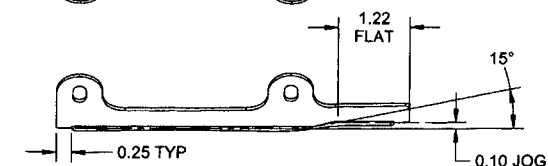
NOTES:
1-5) AS PER D3537-3
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3537-11" PER QSI 044 6.1 (PERMANENT MARKER)
7) WEIGHT: 0.25 lbs
8) APPLY 2059B HARDCOAT WELD BEAD, 0.06 TO 0.13 THICK ON BOTTOM SURFACE, AFTER FORMING
9) WELDING: PER QSI 004
10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.02-0.04 THICK, PER DART QSI 005 4.9

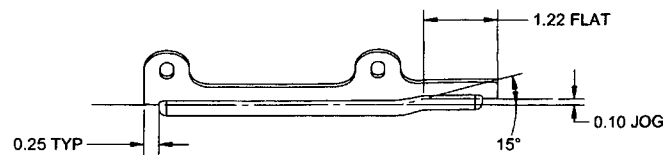| DESIGN	DB	**DART AEROSPACE USA, INC.**	
DRAWN	DB	KENT, WA	
CHECKED	DW	DRAWING NO.	REV. D
MFG. APPR.	DD	D3537	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	WEARPAD	NTS
DATE	14.10.16	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

APPROVED

| DART AEROSPACE LTD		Work Order:	126378
Description: Wear pad		Part Number:	3537-1
Inspection Dwg: 3537 Rev: D			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.97	+/- .030	1.97	✓		V=JKM-01	
3.170	+/- .010	3.173	✓			
3.500	+/- .010	3.499	✓			
3.63	+/- .030	3.624	✓			
4.25	+/- .030	4.259	✓			
.220 x .380	+/- .010	.220 x .381	✓			

Measured by:	Dc	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	14/11/06	Date:	NOV 07 2014	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	